

Date: Friday, 7/4/2008 12:48:28 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BUSHING		
Job Number	: 40277					
Estimate Number	: 10725					
P.O. Number	:		Part Number	: D2652		
This Issue	: 7/4/2008	S.O. No. :	Drawing Number	: D2652 REV A		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: / /	Type	MACHINED PARTS	Drawing Revision	: A	
Previous Run	: 39222		Material	:		
Written By	:		Due Date	: 7/30/2008 Qty: 200 Um: Each		
Checked & Approved By	:					
Comment	: Est Rev.B 02.06.13 Now machined in house. NG					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0500	303 Round Bar 0.500"
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Comment: Qty.: 0.0578 f(s)/Unit Total : 11.5500 f(s)

Material: 303 ss .500" Round Bar

(M303R0500)

Batch: m106996

(94)

mmt 08/07/11

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO FA250 & DWG D2652

FOLIO REV: A

(94)

DWG REV: A

2-DEBURR AS REQUIRED

mmt 08/07/11

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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(94)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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(94)

Comment: SECOND CHECK

08/07/11

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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(94)

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: 39

8/1/11

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 7/4/2008 12:48:28 PM
User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 40277

Part Number: D2652

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/16 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

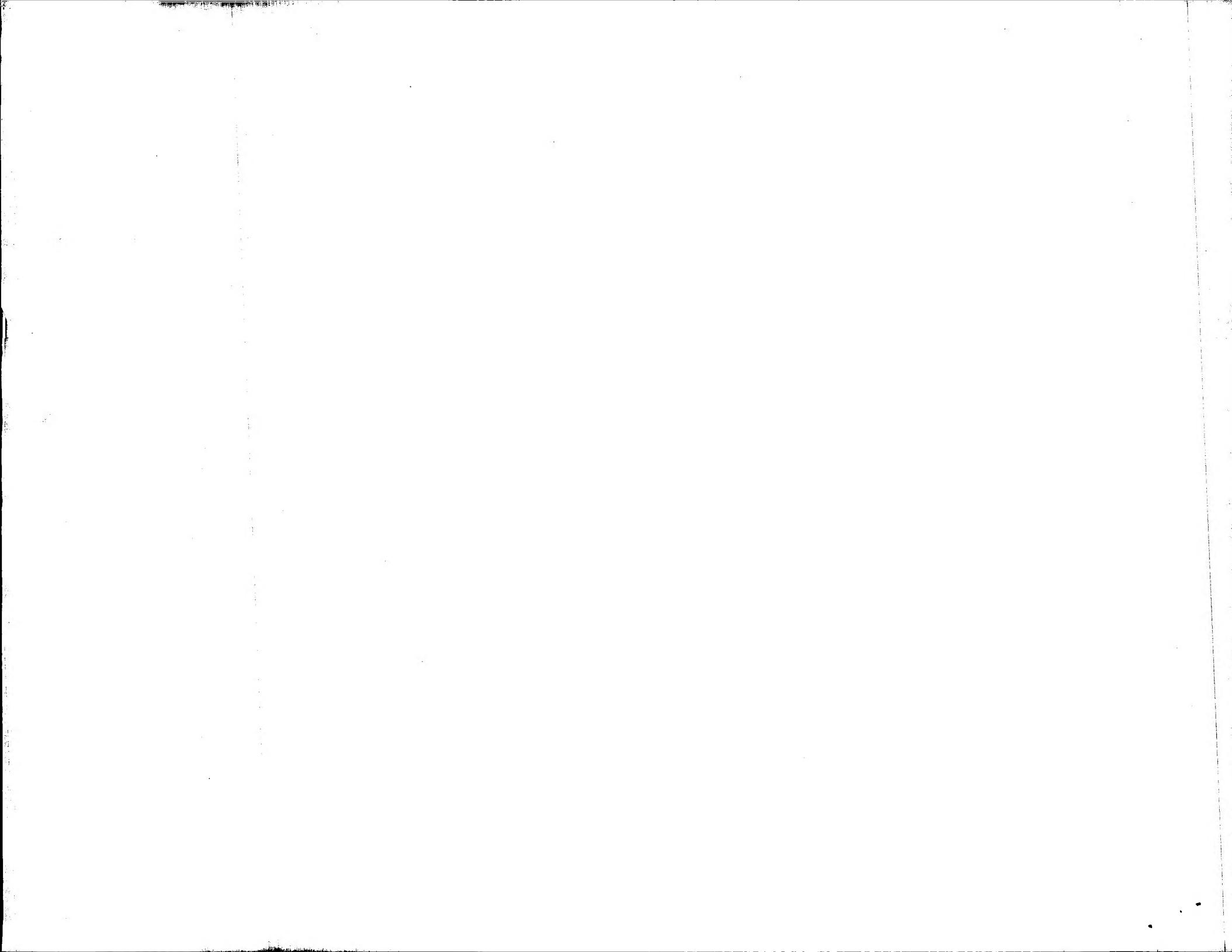
DART AEROSPACE LTD	Work Order:	40277
Description: Bushing	Part Number:	D2652
Inspection Dwg: D2652	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

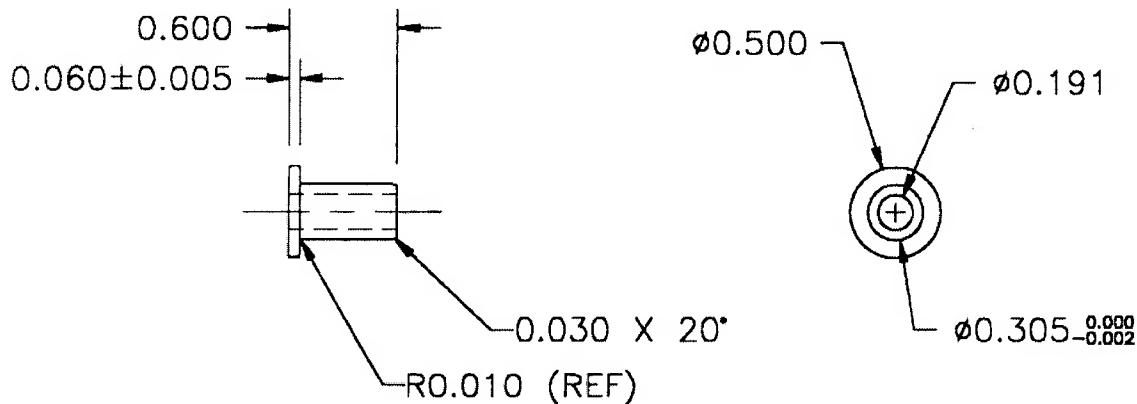
Measured by:	MMJ	Audited by:	DJP	Prototype Approval:	N/A
Date:	08/07/11	Date:	08/07/15	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.12	New Issue	KJ/RF	TT



DART

DESIGN <i>DMY</i>	DRAWN BY <i>DDY</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>BW</i>	APPROVED <i>DDY</i>	DRAWING NO. D2652
DATE 97:03:25	TITLE BUSHING	REV. A SHEET 1 OF 1 SCALE 1:1

RELEASED
97/04/25 DS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40277

MATERIAL: AISI 303 SS

NOTE: BREAK ALL SHARP CORNERS 0.010 MAX

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED